

Wednesday, 6/6/2007 1:59:36 PM

Kim Johnston

## Process Sheet

Split Jan 06-13

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPLATE

Job Number : 32808 - 2

Estimate Number : 12403

P.O. Number : N/A

This Issue : 6/6/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : SMALL / MED FAB

Previous Run : 27679

Part Number : D3511041

Drawing Number : D3511 REV.A

Project Number : N/A

Drawing Revision : A

Material : N/A

Due Date : 6/28/2007

Qty: 10 Um: 8' Each

Written By : J.A.

Checked &amp; Approved By : J.A. 0706-07

Comment : Est Rev:A New Issue 06-05-04 JLM

Est Rev:B New process 06-05-05 EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S188

304 SHEET .188" THICK



Comment: Qty.: 1.5572 sf(s)/Unit Total: 12.4572 sf(s)

304 SHEET .188" THICK

(M304S0188)

Batch: ~~1104699~~ 1104699

SAD 07/08/26

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3511

Dwg Rev: A

Prog Rev: A

2-Debur if necessary

Identify as D3511-1

SAD 07/08/26

⑧

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/26

SAD 07/06/12

P10

last PAGE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EP 07/09/13

SAD 07/06/12





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32808

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.1

D35031

CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

CUP

Batch:

B34494  
B34246

42

022

J.J.L.

07/11/08

(8X)

6.0

SMALL FAB.1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

SB 07/10/18 (8)

~~SB 07/10/13~~

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/18 (8)

8.2

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch: M105754

J.J.L. 07/11/08

(8X)

9.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SB 07/11/30 (8)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-12 (8)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/11/30 (8) <sup>cauto</sup>

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316

FL 07/12/04 (8)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32808

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8X  
07/12/04

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST272

AS

07/12/04

8X

15.0

QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

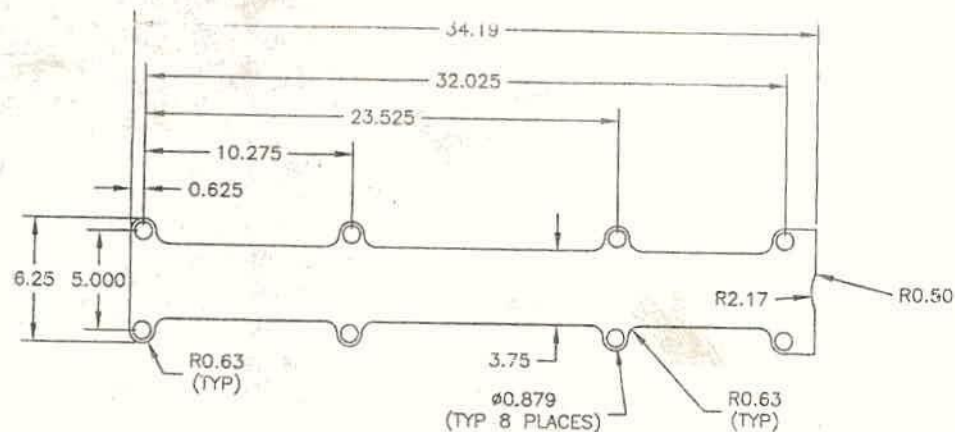
207/12/05

Job Completion



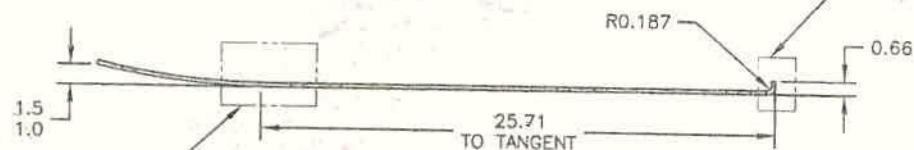
11 07.12.05





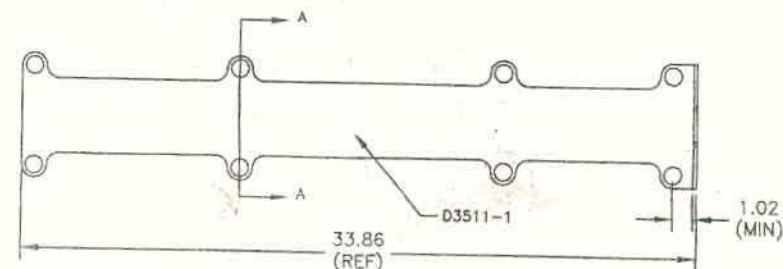
**D3511-1F FLAT PATTERN**

NOTE: BEND BEFORE WELDING



**D3511-1 BEND DETAIL**

NOTE: BEND AFTER WELDING



**SECTION A-A**

**D3511-041 WELD DETAIL**

**D3511-041 WEARPLATE ASSEMBLY**

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)  
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3511-041 WEARPLATE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

RELEASED

06 04 25 #


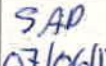



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DESIGN	PH	DRAWN BY	PH	<b>DART AEROSPACE LTD.</b> <small>WINDSOR, ONTARIO, CANADA</small>	
CHECKED	PH	APPROVED	PH	DRAWING NO. <b>D3511</b>	
DATE	06.04.04	TITLE		WEARPLATE SHEET 1 OF 1 SCALE NTS	

SHORT COPY  
 REFLECTED  
 ENGINEERING  
 UNCONTROLLED COPY  
 STREET TOWN  
 WITHOUT NOTICE  
 WORK ORDER  
 32808



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 07/12/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-13	2.0	1st part off of the machine, and the holes are under size due to the taper in the hole from cutting.	 QS1042	Speed was reduced. Split w/o for Qty 1 <u>on this w/o, 11 on original.</u> Bore $\phi$ to size, and complete New F.A.I. sheet.	SAP 07/06/13  07/03/26	 QS1042 07/04/13	 QS1042	 07-06-13

NOTE: Date & initial all entries





